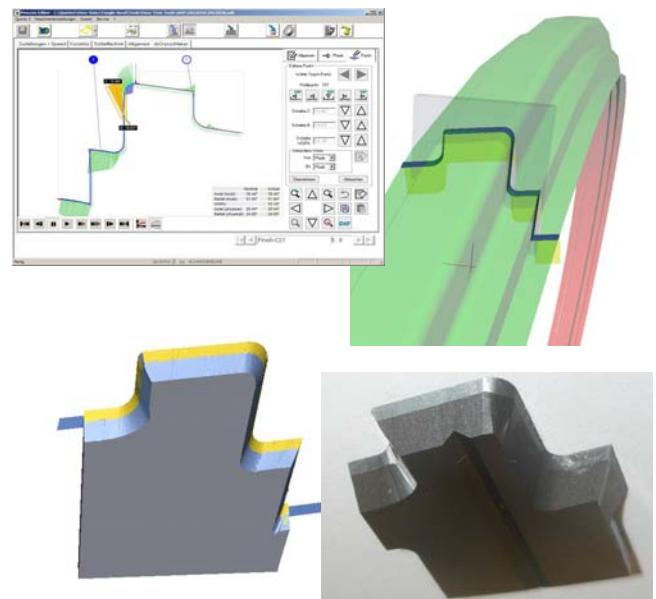


Woodinsert with 2 clearance angles

A09-010

Grinding 2 clearance surfaces on Woodinsert allows to achieve excellent profileprecisions over long production batches keeping edge roughness low. Quinto 5 uses as input the DXF of the woodprofile or, if not known, the profile of the distorted insert copied from the masterinsert. Usually the woodprofile is given, the reference dimensions of the millingcutter and the various orientation angles of the insert. With the 3D view the insert, the side and radial clearances can easily be verified. It is also possible to display the insert on the body of the cutter to verify the geometrical input. In addition a 3D simulation of the grinding process representing the wheelcontact on the clearance surface of the insert can be used. The wheel path is calculated automatically for both clearances. The proposed paths and wheelpositions can be manually modified for all the



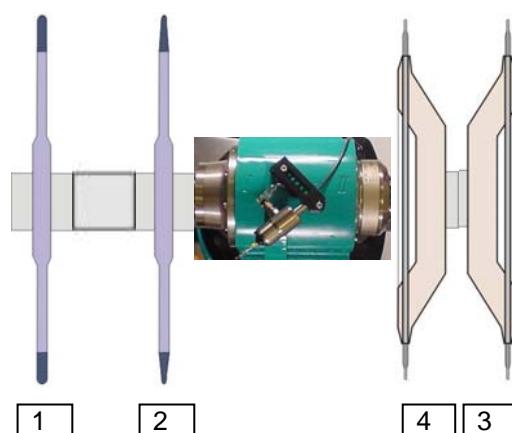
1. Cycletime for Production

Workpiece: blank size: 21x31 mm Material CARBIDE						
Operations	Ref Probe	Prf Rough	Prf Pgrd	Prf fin2nd cl	Prf fin1rst clr	PPC
Feed [mm/Min]	2000	80	80	100	80	100
Power [kW]		2	1	1	1	1
Cutting feed [m/s]		32	22	22	22	22
Used wheels		1	2	3	4	
Grinding time [s]	12	133	65	56	65	36
Total cycle time	6 Min 13					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14F1 Ø300 R2 D91
2	14EE1 Ø300 R1.5 D76
3	14EE1 Ø300 R0.8 D76
4	14EE1 Ø300 R0.4 D46



3. Machine and Software Requirements

Machines:	5 axes CNC grinders : SIRIUS HPM	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 310i	Software:	Quinto 5
Accessories:	STL6050 stack, Lasermarking,Cleaning		

Responsible engineer: OP. 17.2.10

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